

# Work Order ID 78217

**\*78217\***

Page 1

January-02-12 1:24:22 PM

Item ID: D3967-1KGY Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rear Overhead, Center w/ Duct  
 Start Date: 02/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 06/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3967	B

100		0.00							
<b>*100*</b>									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

*DL*  
12/01/03

105		0.00							
<b>*105*</b>									
HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								

*DL*  
12/01/03

Temp: 150°F  
 Time IN: 12/01/02 4:30 pm  
 Time OUT: 2:30 am 12/01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78217****\*78217\***

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January-02-12 1:24:22 PM

Item ID: D3967-1KGY

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rear Overhead, Center w/ Duct

Start Date: 02/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

**\*110\***

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA060 using tool DT9340  
Dwg Rev: B  
Folio Rev: B

DL  
12/01/03

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

DL  
12/01/03

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

B  
12/01/03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

**Work Order ID 78217****\*78217\***

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January-02-12 1:24:22 PM

Item ID: D3967-1KGY

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rear Overhead, Center w/ Duct

Start Date: 02/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

**\*140\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

150

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*150\***

QC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*78217\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 02/01/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 06/01/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Identify as per dwg & Stock Location: Therm

0.00

\*170\*

ΑΠΛ: 604 78115

0.00

### Packaging

## Memo

## Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

## Memo

0.00

QC

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January-02-12 1:24:26 PM

Page 1

Work Order ID: 78217

**\*78217\***

Parent Item: D3967-1KGY

**\*D3967-1KGY\***

Parent Item Name: Rear Overhead, Center w/ Duct

Start Date: 02/01/2012

Required Date: 06/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

IPP RevB:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased	No			100	sf	1,011.893	23.333	23.333			

**\*MKYD6185S 080-P3-52068\***

Kydex steel grey

\*\*

Location

Loc Qty

Loc Code

therm

1011.893107

111807

10.4896282

119476

1001.40348

~~23.333~~

23.333

2/1

12/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

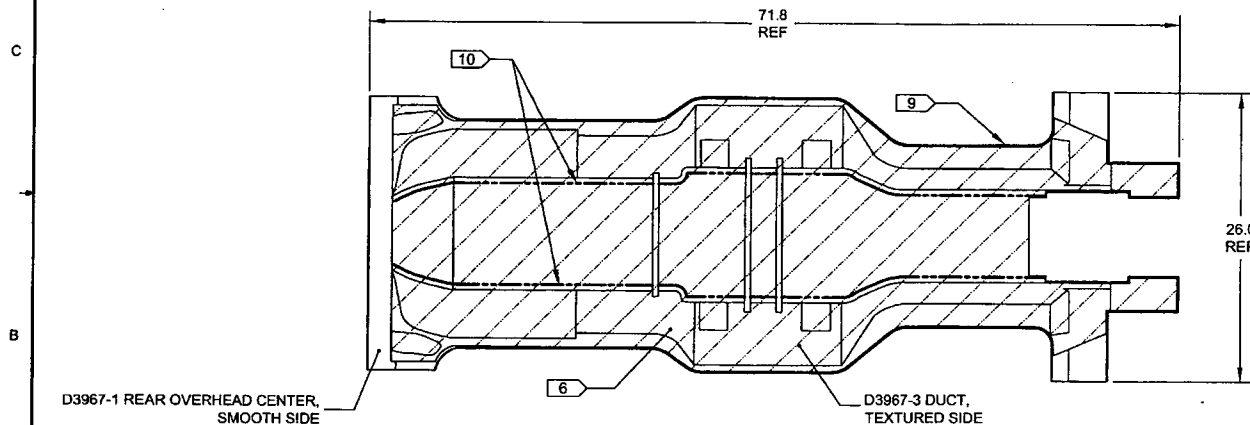
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041 KIV	QTY -041 KGY	PART NUMBER	DESCRIPTION
	X		D3967-041KIV	REAR OVERHEAD CENTER WITH DUCT (IVORY)
		X	D3967-041KGY	REAR OVERHEAD CENTER WITH DUCT (STEEL GRAY)
1	1		D3967-1KIV	REAR OVERHEAD CENTER (IVORY)
2		1	D3967-1KGY	REAR OVERHEAD CENTER (STEEL GRAY)
3	1		D3967-3KIV	DUCT, REAR OVERHEAD CENTER (IVORY)
4		1	D3967-3KGY	DUCT, REAR OVERHEAD CENTER (STEEL GRAY)
10	A/R	A/R	EZ250150	ADHESIVE, 3M SCOTCH WELD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO ANY CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. 78217 M.C.J.

12/01/02



**D3967-041 REAR OVERHEAD CENTER WITH DUCT**

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3967-041KIV OR D3967-041KGY USING VIBRATING STYLUS
- 7) WEIGHT: 10.6 lbs
- 8) TRIM D3967-3 DUCT AS REQUIRED TO ALLOW PROPER MATING
- 9) SEAL MATING EDGES WITH EZ250150 ADHESIVE ALONG MATING PERIMETER WITH MINIMUM THICKNESS OF 0.020"
- 10) RUN BEAD OF EZ250150 ADHESIVE BETWEEN PARTS ALONG INDICATED "-----" CORNERS WITH MINIMUM THICKNESS OF 0.020"

B	ADD -3/-041	PH	09.12.15
A	NEW ISSUE	PH	09.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	09.12.15		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. D3967  
REV. B  
SHEET 1 OF 3  
TITLE REAR OVERHEAD CENTER (206 L3/L4) NTS  
SCALE  
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

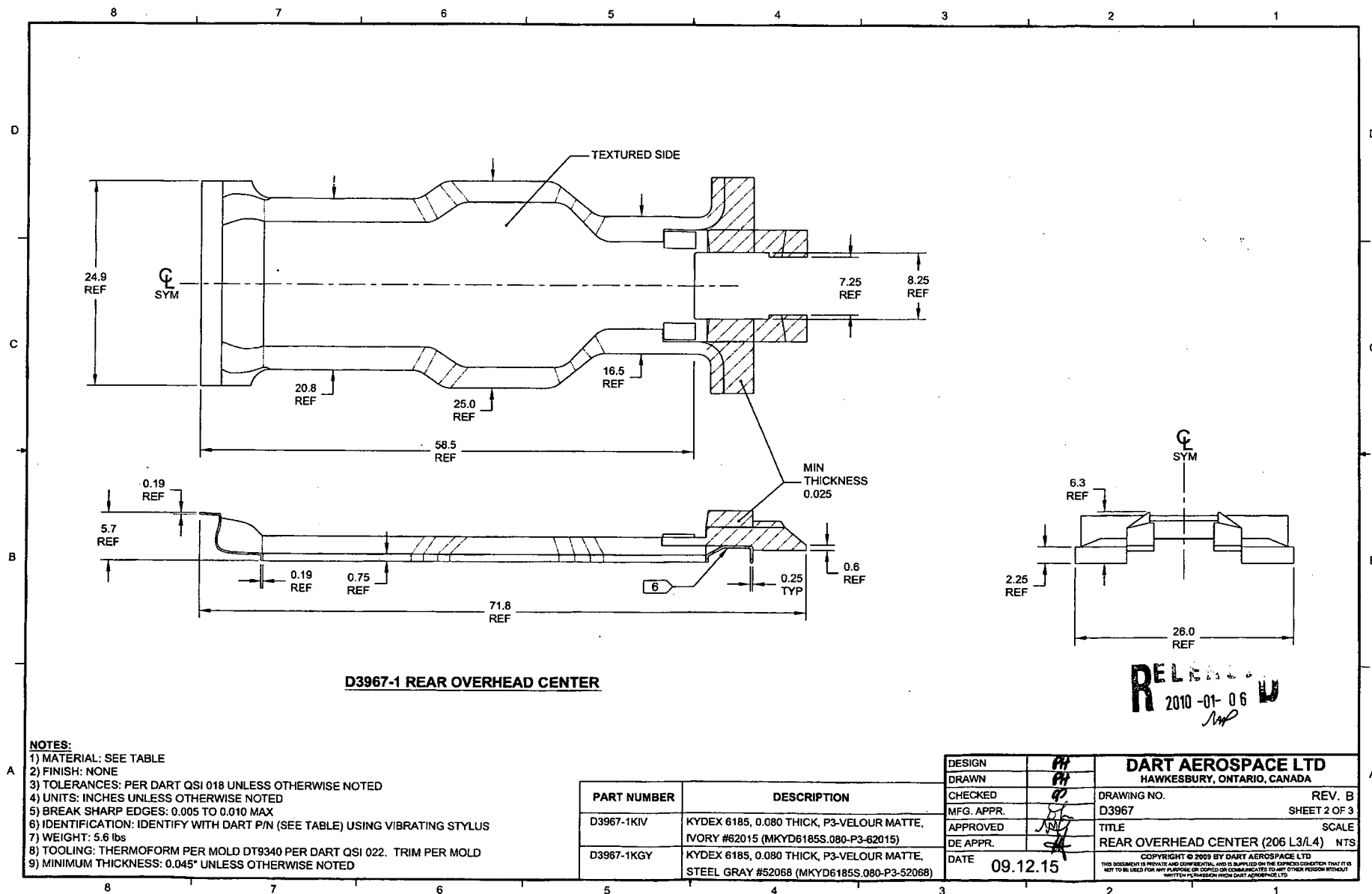
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

78217



W/O:		WORK ORDER CHANGES					
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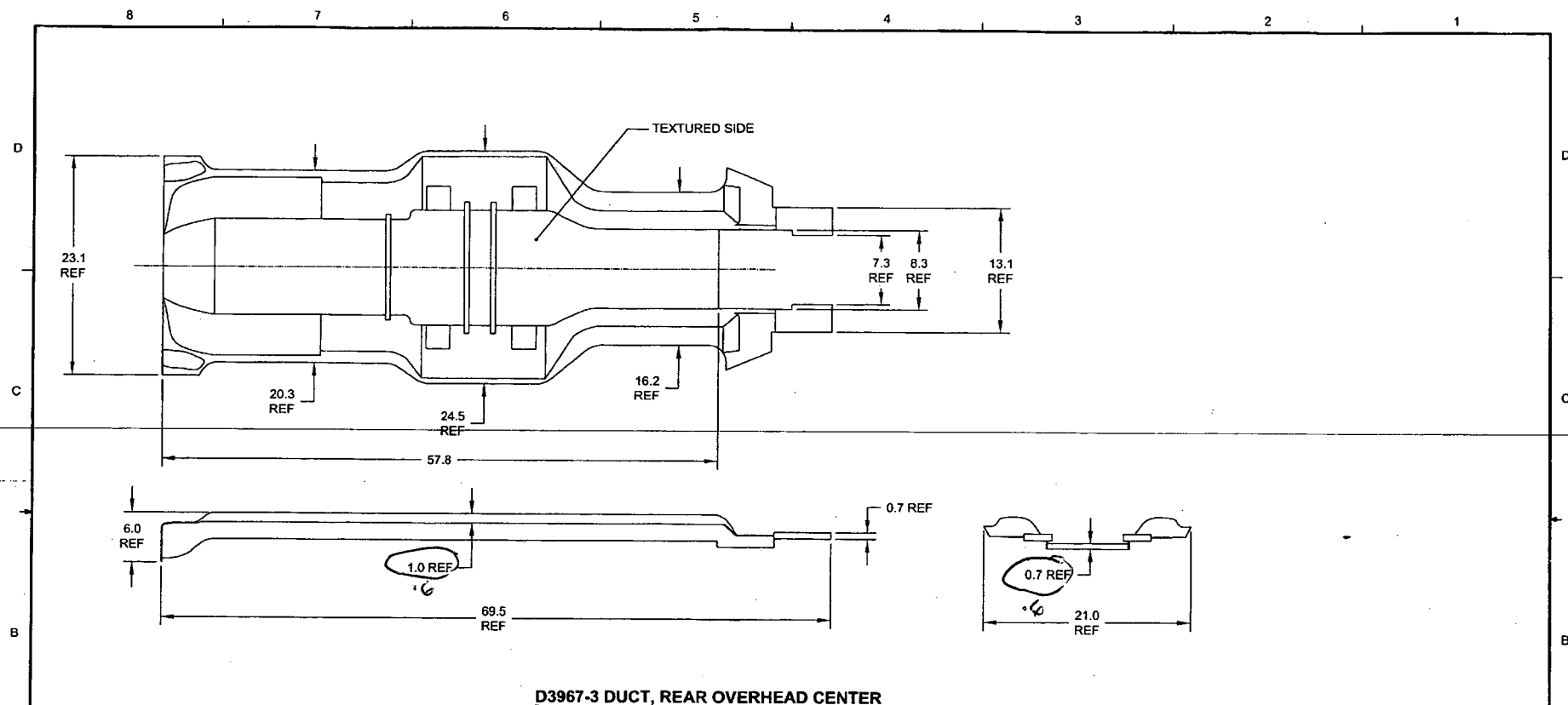
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78217



**D3967-3 DUCT, REAR OVERHEAD CENTER**

**RELEASED**  
2010-01-06

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9339 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.025" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3967-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3967-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3967	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	REAR OVERHEAD CENTER (206 L3/L4) NTS	
DATE	09.12.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28217
<b>Description:</b>	<b>Part Number:</b> D3961-1K6Y
<b>Inspection Dwg:</b> D3967 <b>Rev:</b> <del>A</del> B	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> <u>WLC</u>	<b>Date:</b> <u>12/01/03</u>
--------------------------------	------------------------------

**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
71.8 "	Ref	71.8 "	✓		TAPE DL-01	
24.9 "	Ref	24.9 "	✓		TAPE DL-01	
20.8 "	Ref	20.8 "	✓		TAPE DL-01	
25.0 "	Ref	24.25 "	✓		TAPE DL-01	
16.5 "	Ref	16.5 "	✓		TAPE DL-01	
7.25 "	Ref	7.25 "	✓		TAPE DL-01	
0.75 "	Ref	0.75 "	✓		TAPE DL-01	
2.25 "	Ref	2.25 "	✓		TAPE DL-01	
0.045 "	MIN	0.059 "	✓		VENN DL-02	
0.075 "	MIN	0.030 "	✓		VENN DL-02	

<b>Measured by:</b> <u>WLC</u>	<b>Date:</b> <u>12/01/13</u>
<b>Audited by:</b> <u>S</u>	<b>Date:</b> <u>12/01/13</u>
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*10.04.14*